

# Work Order ID 55551

January 20, 2010 11:04:34 AM

Page 1

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10

Start Qty: 10.00

Required Date: 1/29/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2492

Dwg Rev: F

Prog Rev: F

2-

Deburr if necessary

IR 10-1-21

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

IR 10-1-21

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

⇒ 8/10/10/22

214

Ph ⇒

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>10/05/25</del>	130						

Part No: D2492 PAR #: NCR10-062 Fault Category: Small Pbs. NCR: Yes No DQA: Yes Date: 10-06-23  
 Resolution: rework Disposition: rework QA: N/C Closed: Yes Date: 10/06/23

NCR: 55551-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/25	130	Make 3 to fit the 3 litter kits in stock - ensure fit - match + plug together	10.06.17 Q51042	NO consistency between holes of litter kit + 32nd step see 2 headed UBN	SAD 10-06-09	S 10/06/09	10.06.17 Q51042	S 10/06/09
		R.C. Lack of attention to tooling, & tooling use.						

NOTE: Date & initial all entries

## Under Review Notification

Raised By: C Provencal

Date: 10.05.20

Product #: D350-616

Product Name: Litter Kit

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2492	Patient Stop				N	Y	N	Y	Y	Y	Y	10-577	Quarantine stock, rework per instructions
D2493	Patient Stop Assembly				N	Y	N	Y	Y	Y	Y	10-577	below, OK to ship after rework.
D315-616-011	Full Litter Kit				N	Y	N	N	Y	Y	Y	10-577	Get ENG sign off to produce more, with lower hole removed.

### Description of issue:

- Location of holes in litter kit for installation of patient stop has no consistency between batches.
- Lower hole from D2492 Patient Stop will be removed. As part of assembling litter kit, patient stop will be drilled to match litter. For replacement parts, customer will transfer drill patient stop to fit litter.
- Rework existing stock of D2492/D2493 patient stops to remove lower hole. Any patient stops already in kits that fit their litter are OK as-is.
- Ensure for any D315-616-011 in stock that the patient stop fits the litter.

### Distribution:

General Manager

Production Manager

Director Quality Assurance

Design Manager

Chief Engineer

Production Engineering Coordinators

Quality Assurance Coordinator

Quality Control Coordinator

Order Processing

Customer Technical Support

Engineering Project Managers

Engineering Clerk

Marketing

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Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form using Jig DT2492B

0.00

0.00

SAD 10-06-09

2

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/10

2

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

2 BR 10-6-10.

# Work Order ID 55551

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Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

HL

10/06/10

2 4

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

⇒ HL

10/06/11

x2 0

START TIME:

8:15AM

8:45PM FINISH TIME:

OVEN TEMPERATURE:

320°F

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 BR 10-6-11

# Work Order ID 55551

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Item ID: D2492

Accept



Setup Start



Revision ID:

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Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location 208

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-6-15 (208) [Signature]  
10/06/23 [Signature]  
MF  
10-6-16

# Picklist Print

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Work Order ID: 55551



Parent Item: D2492

Parent Item Name: Patient Stop

Start Date: 1/20/10

Required Date: 1/29/10

Comments: IPP E 00.06.26 Removed P/O for powder coat EC  
IPP Rev:F Now 6061-T6 06-06-23 JLM  
IPP Rev:G now water jet 07-12-11 DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last
M6061T6S.080		Purchased	No		

Route	Unit of	Qty on	Remaining	Qty	Date	Status
100	sf	178.9597	19.1884			



6061-T6 .080 Sheet

B10-1-21

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

178.95967

110630

35.0136

112141

0.86727

112763

6.85

113438

136.2288

113438

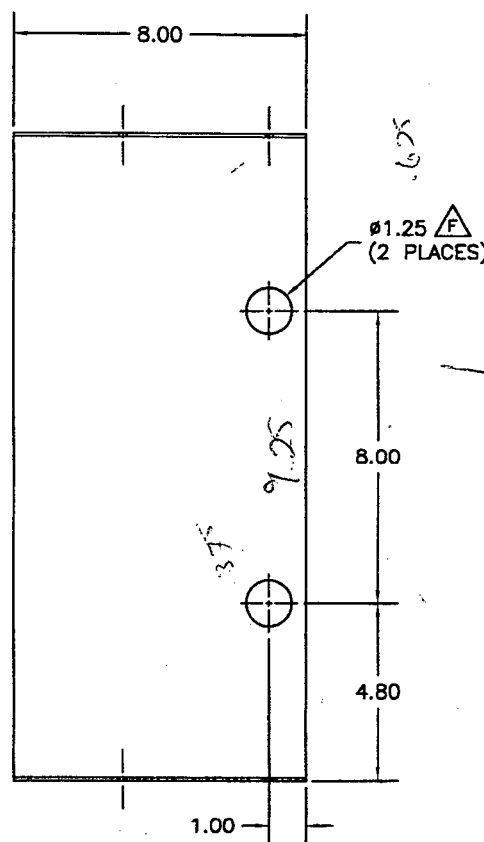
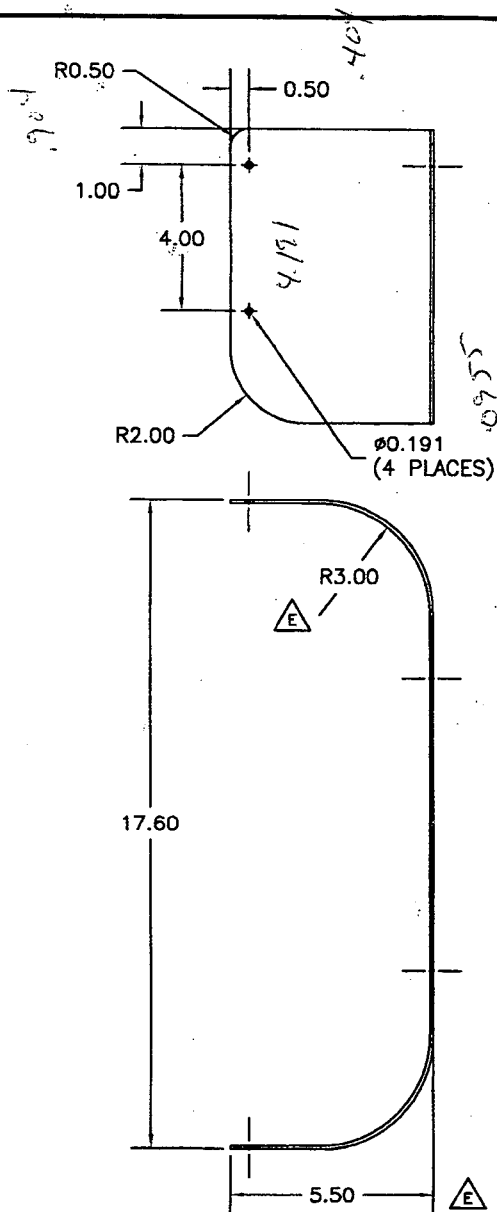
15







DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	



#### D2492 PATIENT STOP

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED

06.09.14 *[Signature]*

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